

Work Order ID 110423

December-19-13 2:10:56 PM

110423

Page 1

Item ID: D2432

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw 19" X 24"

Start Date: 12/19/13 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/27/13 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLSDate: 12-19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

H

120

120

FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

1616 0 14-02-21

130

130

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2432 Identify as D2432F
 3-Debur

16 0 14-02-28

140

140

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

16 0 14-02-28

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Item ID: D2432 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw 19" X 24"
 Start Date: 12/19/13 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 12/27/13 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150						16			14-3-12
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
32
9-89

14-03-17

Picklist Print

December-19-13 2:11:00 PM

Page 1

Work Order ID: 110423

110423

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 12/19/13

Required Date: 12/27/13

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERFJLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

120

sf

196.7082

3.7

60

MUHMWB10

**

Jm14-02-21

UHMW 1" Black - 48"x120"

Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT018

196.7082

121278

9.6282

122575

47.6

123229

53

123949

6.96

124758

17.52

m126748

21

m127491

41

128267

128267

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

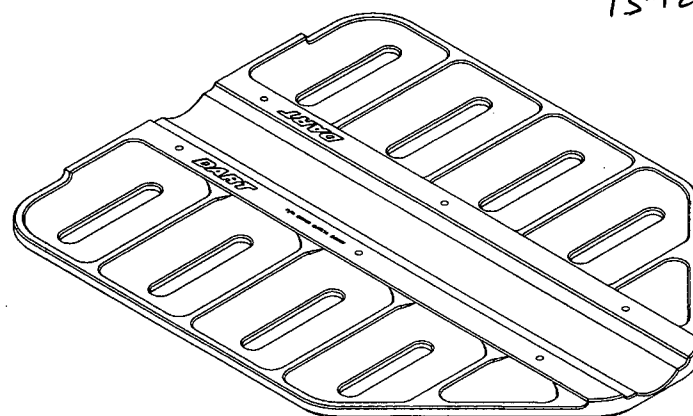
DART AEROSPACE LTD		Work Order:	110423
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	.060x45	✓		SLO8	Vern
5.500	+/-0.030	5.501	✓			
0.200	+/-0.030	.200	✓			
0.25 x 45°	+/-0.030	.250x45	✓			
R0.250	+/-0.030	.250	✓		Rad gauge	
0.250	+/-0.010	.255	✓			
0.625	+/-0.030	.625	✓			
0.375	+/-0.010	.375	✓			
0.950	+0.030/0.010	.965	✓			
19.000	+/-0.030	19.000	✓			
3.14	+/-0.030	3.140	✓		SLO1	Tape
3.28	+/-0.030	3.280	✓			
Ø0.260	+0.005/-0.000	.260	✓			
Ø0.93	+/-0.030	.930	✓			
0.30	+/-0.030/-0.000	.295	✓			
23.750	+/-0.030	23.750	✓		SLO1	Tape
4.250	+/-0.010	4.250	✓			
2.000	+/-0.030	2.000	✓			
9.000	+/-0.010	9.000	✓			
9.000	+/-0.010	9.000	✓			
0.375	+/-0.010	.375	✓			

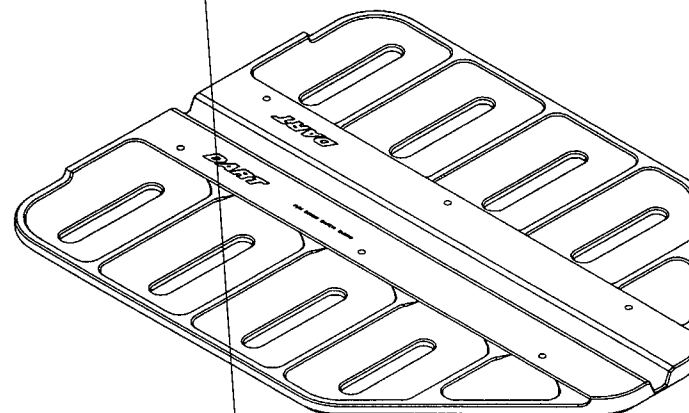
Measured by:	<i>SL</i>	Audited by:	<i>SL</i>	Preliminary Approval:	
Date:	14-02-27	Date:	14-3-12	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	<i>MA</i>



D2432F BEARPAW

110423 MLJ
13-12-19

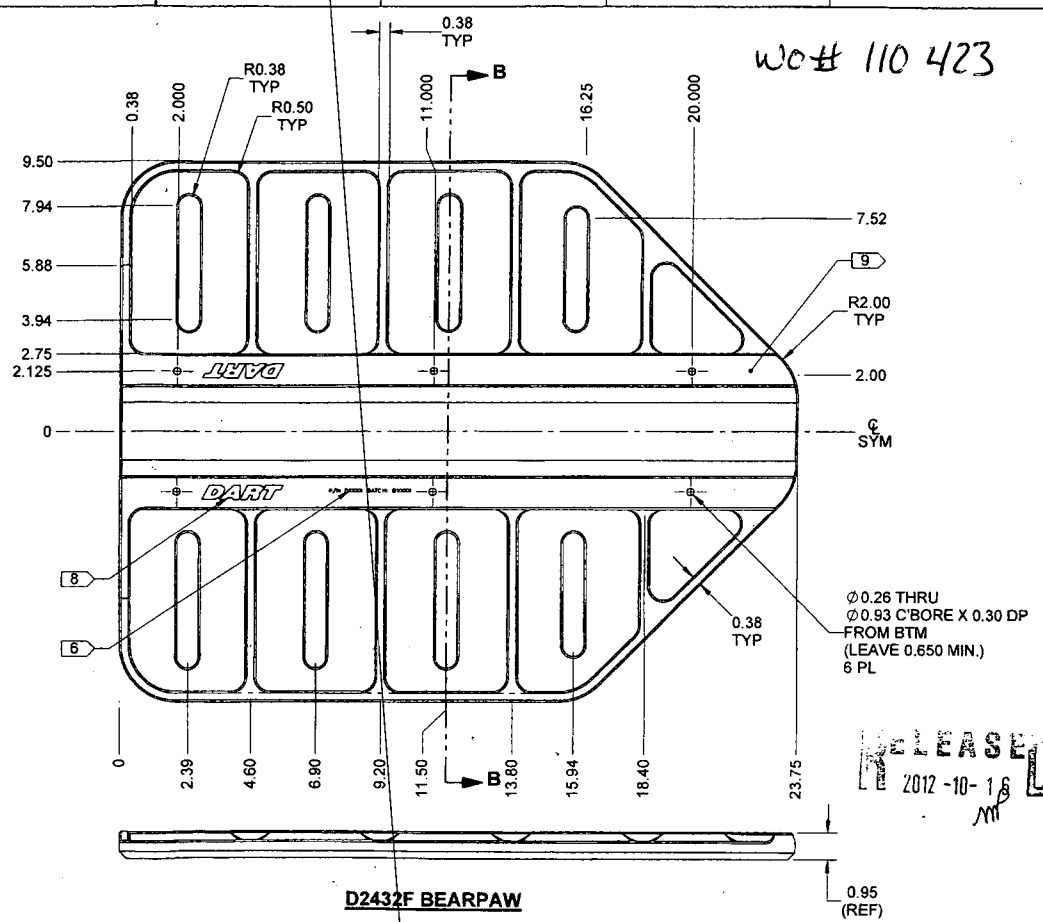
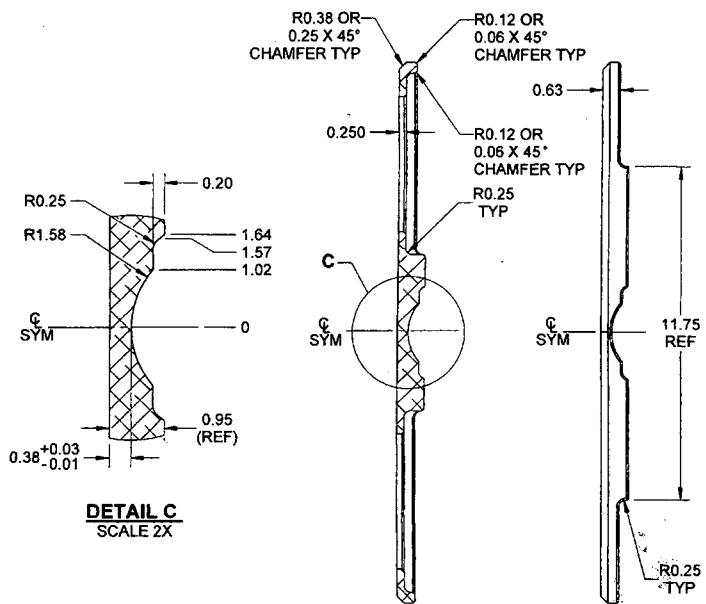


D2432-3 BEARPAW

RELEASED
2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	91	D2432	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	141	BEARPAW	NTS
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WO# 110 423



- NOTES:**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
 - 7) WEIGHT: 5.87 lbs
 - 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
 - 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
 - 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	41	D2432	SHEET 2 OF 3
APPROVED	142	TITLE	SCALE
DE APPR.	142	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1986 BY DART AEROSPACE LTD	
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